

Work Order ID 109304

November-18-13 3:17:13 PM

\*109304\*

Page 1

Item ID: D4435-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4435	B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr as required

6061.040

34

0

Im 13-11-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

34

0

Im 13-11-20



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\*20\*

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 13/11/20				34 count			
130 *130* Brake NC Brake NC	Bend as per dwg Small Fab  Memo	0.00 0.00		68-6 30 SVD		34			13/11/20
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O NC BRAKE  Memo	0.00 0.00 DAS 27 9-89 13/11/21				34 count			



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Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: Date: Tooling: Date:

Stop \*NR2\*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00				34	0	CF 13-11-21	
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*160*</b>									
QC	Memo	0.00				34	0	13-11-22	DAS 34 9-89
Quality Control									
165	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*165*</b>									
Powdercoat	Memo	0.00				34	0	13-11-22	CF/12
Powder Coating									
	START TIME: 10:35								
	OVEN TEMPERATURE: 320°C								
	FINISH TIME: 10:55								



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Item ID: D4435-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 11/18/13 Start Qty: 20.00 \*20\*

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 20.00 \*20\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	DAS 27	9-89	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC3- Inspect Part Finish

0.00

13/11/20

\*170\*

QC

Memo

Quality Control

34

180

Identify as per dwg & Stock Location:

0.00

\*180\*

Packaging

Memo

Packaging

51273

0.00

34x

DAS  
28  
9-89

13-11-22

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

Quality Control

0.00

13/12/04

13-12-4





# Picklist Print

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Work Order ID: 109304

Parent Item: D4435-9

Parent Item Name: Bracket

Start Date: 11/18/13

Required Date: 11/18/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 11-12-22 JLM VERIFIED BY:EC IPP REV:B 12.01.24 PER DWG  
REV.A DD VERF:EC IPP REV:C 12.03.06 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	401.2910	0.022	①			

*Jm 13-11-20*

Location

Loc Qty

Loc Code

MAT021

401.291

m126350

209.291

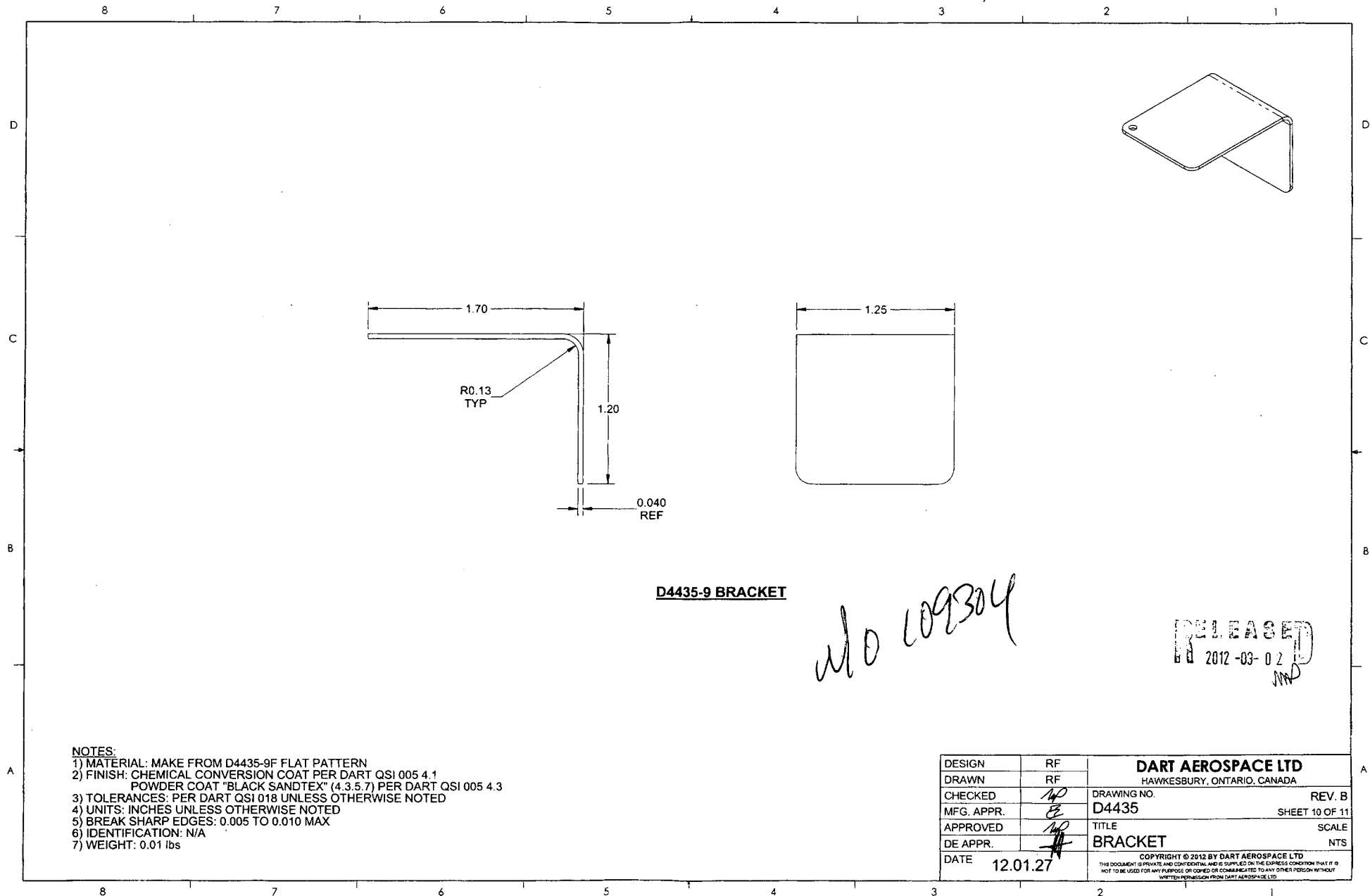
m126981

192

126981







**D4435-9 BRACKET**

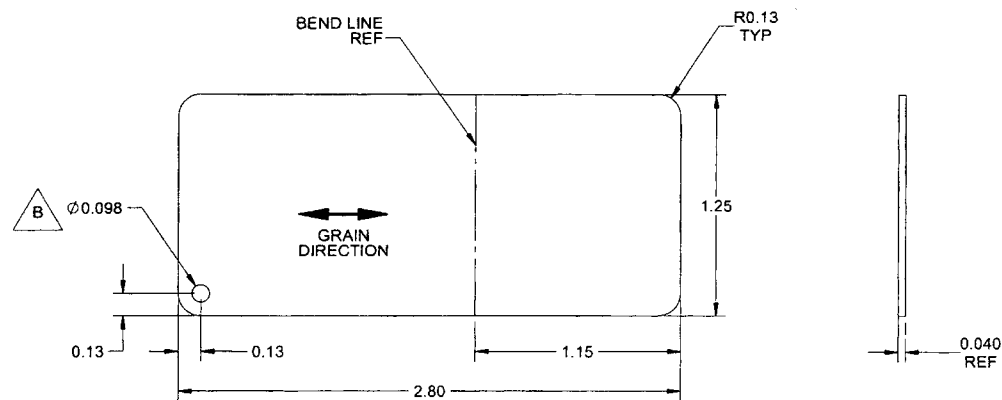
*W/O 109304*

RELEASED  
2012-03-02

**NOTES:**

- 1) MATERIAL: MAKE FROM D4435-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>14</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4435	SHEET 10 OF 11
APPROVED	<i>14</i>	TITLE	SCALE
DE APPR.	<i>#</i>	BRACKET	NTS
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# **D4435-9F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. <b>D4435</b>	REV. B
MFG. APPR.	<i>RF</i>	SHEET 11 OF 11	
APPROVED	<i>RF</i>	TITLE <b>BRACKET</b>	SCALE
DE APPR.	<i>RF</i>	NTS	
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RELEASE  
2012-03-02  
JW